



WB4555E MMA WELDING ELECTRODE

Classifications	AWS A5.4: E309L-16		BS EN ISO 3581-A: E23 12L R 1 2							
Product Description	All positional, rutile coated, 309L stainless steel electrode. Excellent deslag and outstanding welding properties.									
Applications	Used mainly for welding stainless steels and wrought and cast alloys to carbon steels such as 304 clad steels. This is known as a transition weld used largely for pressure vessel fabrications. For cladding it deposits a 308-type deposit on carbon steel and can be followed by 307-weld metal. 8-20FN range.									
All-Weld Metal Composition (Wt. %)	C	Mn	Si	S	P	Mo	Cr	Ni	Cu	
	min. 0.01 max. 0.04	0.5 1.2	0.60 0.90	- 0.020	- 0.025	- 0.15	22.0 24.0	12.0 14.0	- 0.20	
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength		N/mm ²		595					
	Yield Stress/0.2% Proof Stress		N/mm ²		458					
	Elongation on 5D		%		39					
	Impact Energy CV @ +20°C		Joules		74					
	Impact Energy CV @ -50°C		Joules		68					
	As welded									

Electrode Dia. (mm)	1.6mm	2.0mm	2.5mm	3.2mm	4.0mm	5.0mm	6.0mm
Electrode Length (mm)	-	-	350	350	350	350	-
Current Range (Amps)	min.	-	60	80	100	130	-
	max.	-	90	120	150	210	-
Packaging Information							
Kg Per Packet	-	-	5	5	5	5	-
Approx. Pieces Per Kg	-	-	50	30	19	12	-
Storage and Re-drying	<p>Storage It is recommended that the WB range of electrodes are stored in a dry heated store at a minimum temperature of 18°C, and a maximum relative humidity of 60%. To avoid damage to the coatings no more than 4 cartons should be staked on top of another.</p> <p>Re-drying Re-dry @ 350°C for 2 hours and then transfer to holding oven and hold @ 100 - 200°C, or 50-100°C in heated quiver.</p>						

Current Conditions AC OCV70 DC +/- and Welding Positions

